

Date: Thursday, 6/21/2007 2:29:08 PM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|--|--|------------------|---------------|----|----------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : WEARPLATE | | |
| Job Number | : 33055 | | | | | |
| Estimate Number | : 10288 | | | | | |
| P.O. Number | : N/A | | Part Number | : D25771 | | |
| This Issue | : 6/21/2007 S.O. No. : N/A | | Drawing Number | : D2577 REV E | | |
| Prsh Rev. | : NC | | Project Number | : N/A | | |
| First Issue | : N/A | | Drawing Revision | : E | | |
| Previous Run | : 32649 | | Material | : N/A | | |
| Written By | | | Due Date | : 7/10/2007 | | |
| Checked & Approved By | | | | Qty: | 30 | Um: Each |
| Comment | : Est: E 02.09.24 Re-format; Incorporated D2577-101/11 K J/RF est F 06.09.11 now waterjet EC | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|--|
| 1.0 | M1010S16GA | 1010/1025/A21/6aA SHEET |
| | | |
| Comment: Qty.: 0.8474 sf(s)/Unit Total : 25.4205 sf(s) B# 4104948 1010/1025/A21/6aA SHEET IB 07-07-22 | | |
| 2.0 | WATER JET | FLOW WATER JET |
| | | |
| Comment: FLOW WATER JET 1-Cut as per Dwg D2577 (D2577-101 detail) Dwg Rev: E Prog Rev: E | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE IB 07-07-22 | | |
| 4.0 | QC8 | SECOND CHECK |
| | | |
| Comment: SECOND CHECK Sp 07/07/23 | | |
| 5.0 | BRAKE NC | NC BRAKE |
| | | |
| Comment: NC BRAKE 1-Form on brake as per Dwg D2577 using DT8155 and DT8179 2-Form joggle as per Dwg D2577 using DT8157 3-Identify as D2577-1 4-Deburr if nesasary FF 07-08-08 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 04/08/28
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:29:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33055

Part Number: D25771

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Ex 07/08/08

created

Comment: INSPECT WORK TO CURRENT STEP

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



LARGE FABRICATION RESOURCE 1



X7D

Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

Batch

A/R 7560 Hardcoat Rod

M104721 / M105138 FC 07/08/23 (30)

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/27 (30)

9.0 POWDER COATING POWDER COATING



M104 84

30X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-h 07/08/28

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ex 07/08/28

(30)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-15

Ex 07/08/28 (30)

(30)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/08/28

Job Completion



u 07/08/28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 33055 |
| Description: Wearshoe | Part Number: | D2577-1 |
| Inspection Dwg: D2577 Rev: E | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|-----------------|-------------|-----------------|---------------------|-----|
| Measured by: | <u>HB</u> | Audited by: | <u>SP</u> | Prototype Approval: | N/A |
| Date: | <u>07-07-22</u> | Date: | <u>07/07/22</u> | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.06.14 | New Issue | KJ/JLM | BE |

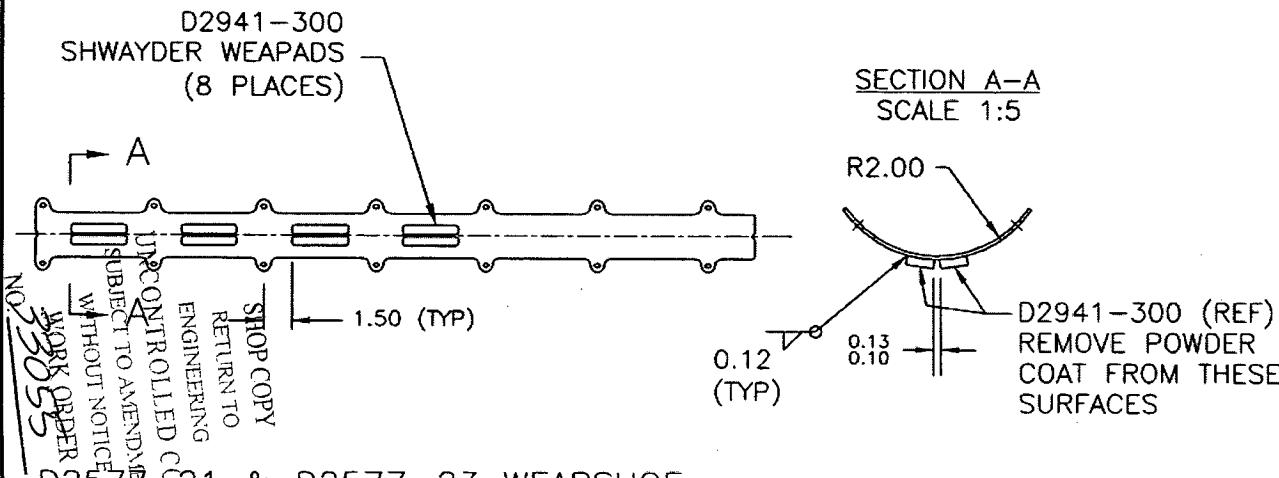
7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
Rev. 04 26 #1



D2577-21 & D2577-23 WEARSHOE

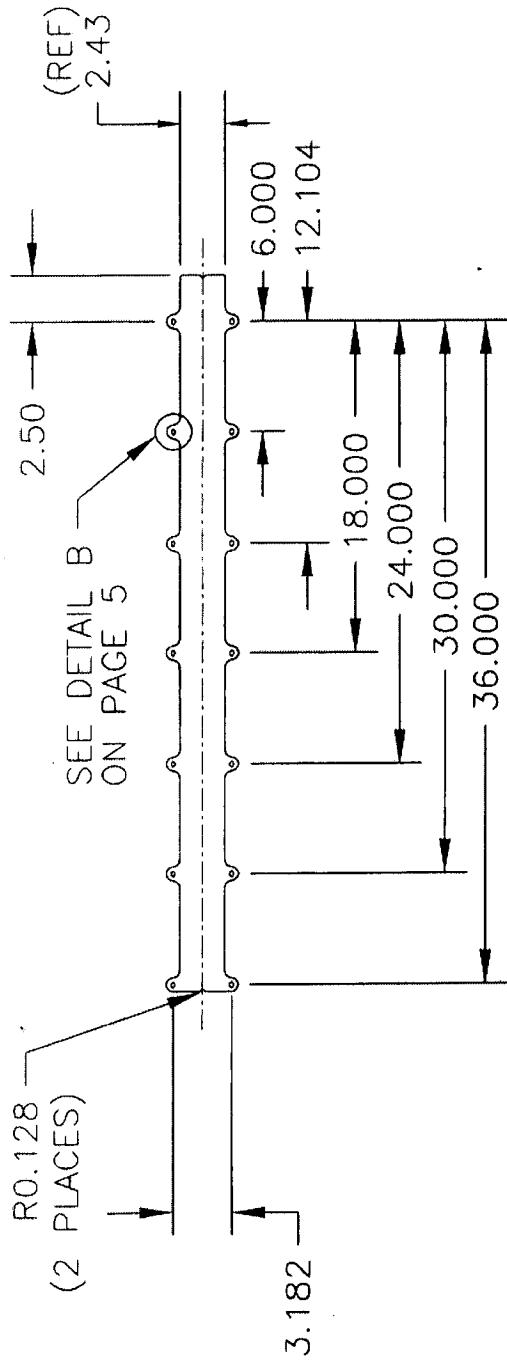
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | REV. E |
|---------|----------|---|--------------|
| CHECKED | APPROVED | DRAWING NO. | SHEET 1 OF 5 |
| DATE | | TITLE | SCALE |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.04 | ADD HARDCOAT WELDS | |
| C | 97.05.30 | CHANGE HOLES TO OBOUNDS | |
| D | 98.08.17 | CORRECTED DIMENSIONS ON -1 & -3 | |
| E | 00.09.22 | ADD D2577-101/-11/-13 INCORPORATE DE09176 | 1:10 |

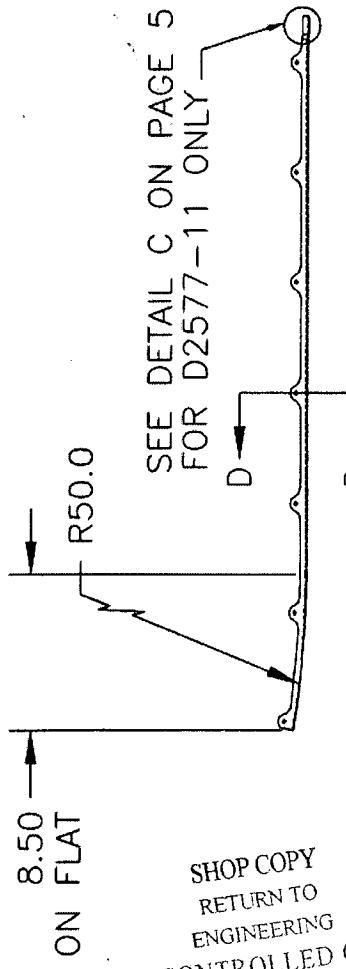
DART

| | | |
|---------|----------|--|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D2577 |
| DATE | | REV. E SHEET 2 OF 5 TITLE WEARSHOE SCALE 1:10 |

D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A569/A570
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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WORK ORDER
NO. 33055

D2577-11 & D2577-13 LONGITUDINAL BEND
MAKE FROM D2577-101
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

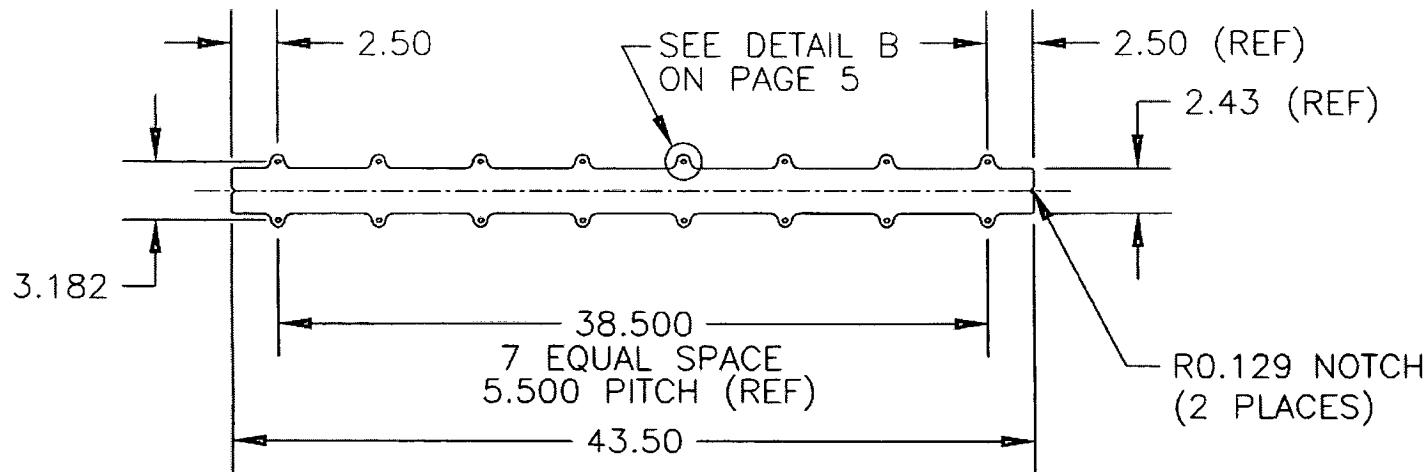
DART



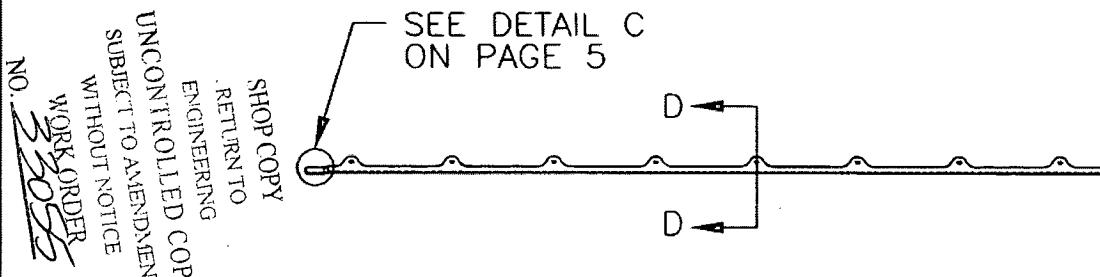
| | | | |
|----------|----------|--------------------|-----------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD | |
| 44 | GP | | |
| CHECKED | APPROVED | DRAWING NO. | HAWKESBURY, ONTARIO, CANADA |
| | | D2577 | SHEET 3 OF 5 |
| DATE | | TITLE | REV. E |
| 00.09.22 | | WEARSHOE | 1:10 |

RELEASED
00.09.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



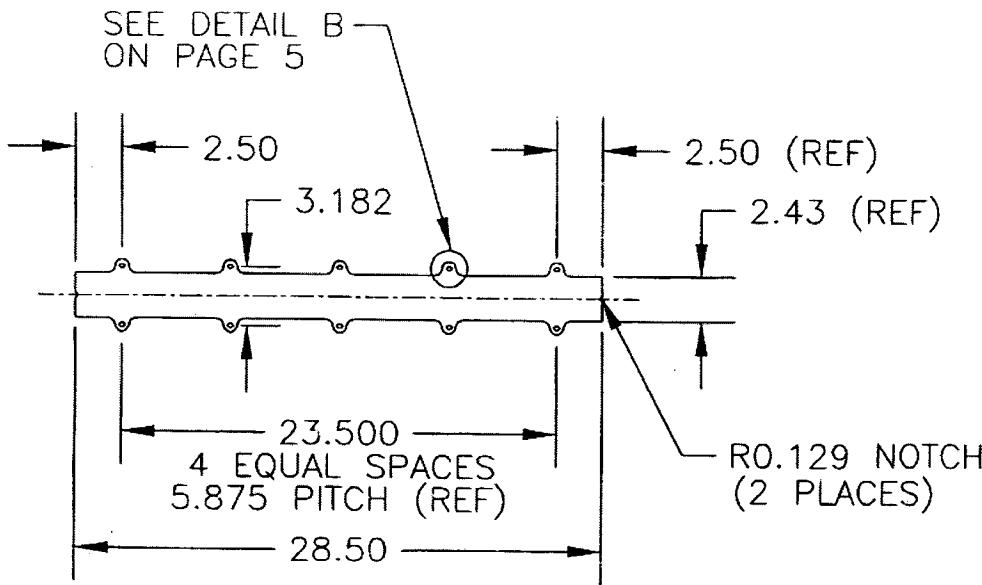
D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
 SERIES STEEL 0.063 THICK
 FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

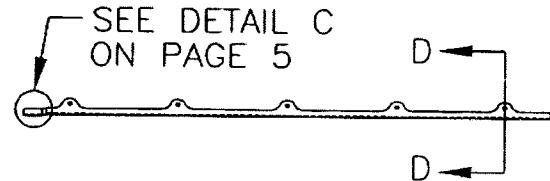
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D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



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D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

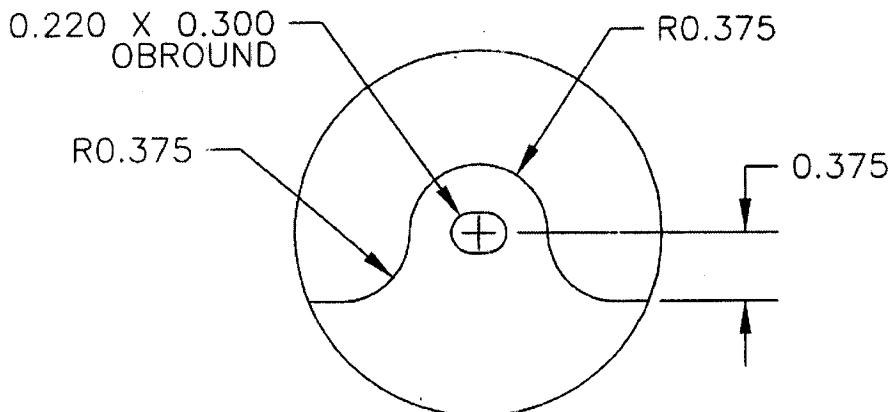
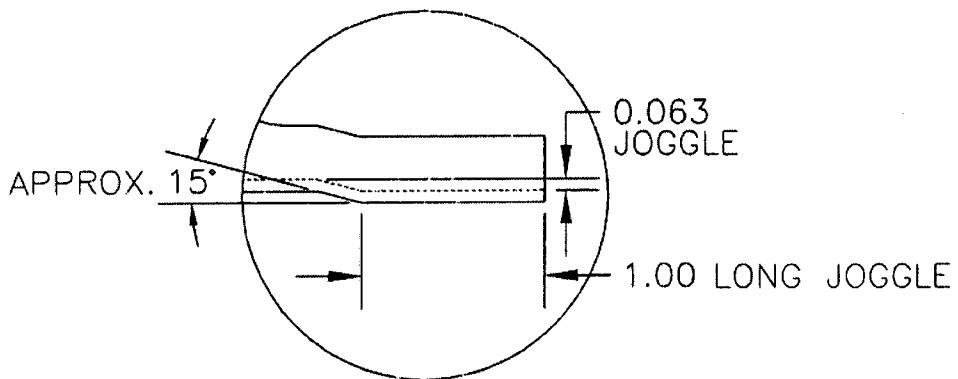
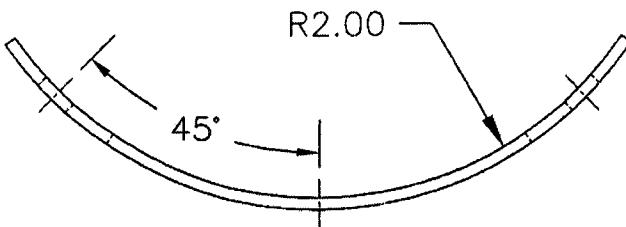


| | | | |
|-------------------------------|--------------------------------|-----------------------------|---------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA | |
| DATE 00.09.22 | DRAWING NO. D2577 | REV. E | |
| | TITLE WEARSHOE | SHEET 4 OF 5 | SCALE 1:10 |

RELEASED
09-26-96

DART

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2577 | REV. E SHEET 5 OF 5 |
| DATE 00.09.22 | | TITLE WEARSHOE | SCALE 1:10 |

DETAIL B (SCALE 1:1)**RELEASED**
00.09.26DETAIL C (SCALE 1:1)SECTION D-D (SCALE 1:1)

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